

Work Order ID 115546

Friday, April 04, 2014 2:21:00 PM

115546

Page 1

Item ID: EA20469-16

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Arm Rest Assembly (Vrd)

Start Date: 4/4/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 4/8/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

100

0.00

100

Purchasing

Purchasing

Memo

ISSUE PO

EAGLE COPTERS

SHIP ONE EACH TO EAGLE FOR ASS'Y:

1 X D4324-041 B

1 X D4324-043 B

0.00

DAS
42
9-89

APR 04 2014

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Packaging

Memo

0.00

DAS
42
9-89

APR 04 2014

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115546

Page 2

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Revision ID:

Stop ***NS2***

Item Name: Arm Rest Assembly (Vrd)

Start Date: 4/4/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/8/2014 Req'd Qty: 1.00

1

Customer:

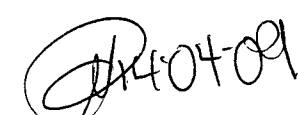
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00					DAS 42 9-89		APR 04 2014
130 *130* Packaging Packaging	Identify as per dwg & Stock Location:  Memo	0.00 0.00					DAS 42 9-89		APR 04 2014
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>MCJ 1404-09</u> 

Picklist Print

Friday, April 04, 2014 2:21:23 PM

Page 1

Work Order ID: 115546

115546

Parent Item: EA20469-16

FA20469-16

Parent Item Name: Arm Rest Assembly (Vrd)

Start Date: 4/4/2014

Required Date: 4/8/2014

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4324-041		Manufactured	No				Each	3.0000		1			
D4324-041													
Armrest Assembly													

Location

Loc Qty

Loc Code

ST103

3

113507

2

84221

1

D4324-043		Manufactured	No				Each	1.0000		1			
D4324-043													
Arm Support Assembly													

Location

Loc Qty

Loc Code

ST103

1

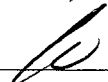
113506

1

EA20469-16P		Purchased	No				Each	0.0000		1			
FA20469-16P													
Arm Rest Ass'Y (Vrd)													

**  1 **DAS**
42
9-89 APR 04 2014

**  1 **DAS**
42
9-89 APR 04 2014

** 1 
Eagle LT13-016840 

Work Order ID 115546

115546

Page 1

April-04-14 7:08:49 AM

Item ID: EA20469-16

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Arm Rest Assembly (Vrd)

Start Date: 4/04/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 4/08/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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100		0.00							
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100

Purchasing

Memo

0.00

Purchasing

ISSUE PO 23643
EAGLE COPTERS
SHIP ONE EACH TO EAGLE FOR ASS'Y:
1 X D4324-041 B
1 X D4324-043 B

CL 14/04/04 ①

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
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110

Packaging

Memo

0.00

Packaging

 ①

April-04-14 7:08:49 AM

Page 2

Quality Control

APR 09 2014

Picklist Print

April-04-14 7:08:48 AM

Page 1

Work Order ID: 115546

115546

Parent Item: EA20469-16

FA20469-16

Parent Item Name: Arm Rest Assembly (Vrd)

Start Date: 4/04/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4324-041		Manufactured	No				Each	3.0000		1			
D4324-041									**				
Armrest Assembly													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST103				3					
				113507				2					
				84221				1					
D4324-043		Manufactured	No				Each	1.0000		1			
D4324-043									**				
Arm Support Assembly													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST103				1					
				113506				1					
EA20469-16P		Purchased	No				Each	0.0000		1			
FA20469-16P									**				
Arm Rest Ass'Y (Vrd)													

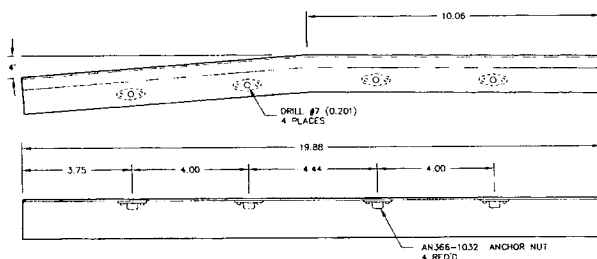
CY 14/04/104

CY 14/04/104

NOTICE

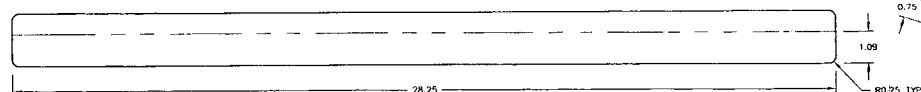
THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AESO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AESO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AESO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
2	ADDED SHEET 3 / MODIFIED ITEMS 10, 11, 12 & 17 / REMOVED ITEM 9 / ADDED ITEMS 29 34 AND 7	DW	01 AUG 2000



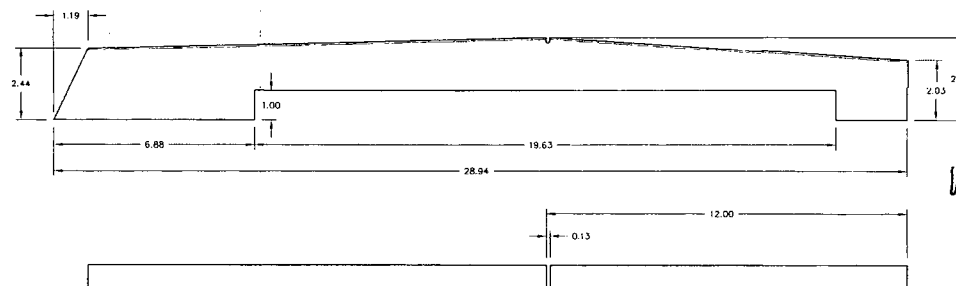
11 ANGLE

SCALE 1 : 2



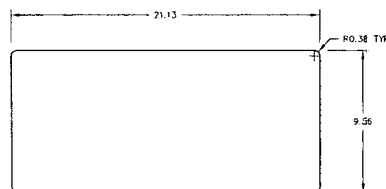
⑦ ANGLE

SCALE 1 : 1



(17) ANGLE

SCALE 1 : 2



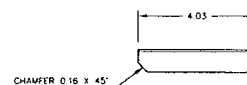
(21) DOOR COVER PANEL

SCALE 1 : 2



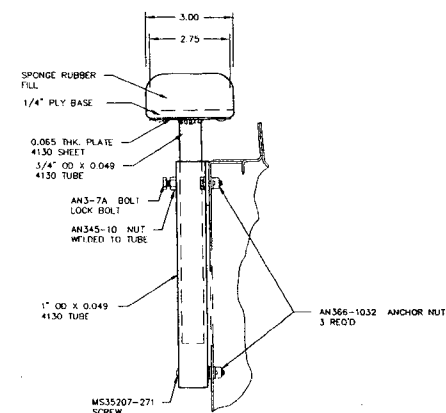
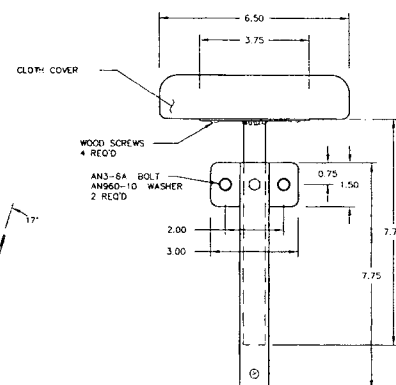
(30) ANGLE

SCALE 1 - 2



(33) ANGLE

SCALE 1 - 2



ARM REST ASSEMBLY

SCHEM 1: 2

QTY	DASH NO	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	34	REARWARD ROB WEB	ALUM. ALLOY 2024-T3	Q0-A-250/5	0.040" THK. SHEET
1	33	ANGLE	ALUM. ALLOY 2024-T3	Q0-A-250/5	0.75 X 0.75 X 0.063 EXTRUSION
1	32	ANGLE	ALUM. ALLOY 2024-T3	Q0-A-200/3	0.75 X 0.75 X 0.063 EXTRUSION
1	31	FORWARD ROB WEB	ALUM. ALLOY 2024-T3	Q0-A-250/5	0.040" THK. SHEET
1	30	ANGLE	ALUM. ALLOY 2024-T3	Q0-A-200/3	0.75 X 0.75 X 0.063 EXTRUSION
1	29	ANGLE	ALUM. ALLOY 2024-T3	Q0-A-200/3	0.75 X 0.75 X 0.063 EXTRUSION
1	28	DOOR COVER PANEL	ALUM. ALLOY 2024-T3	Q0-A-250/5	0.040" THK. SHEET
1	18	DOOR INNER SKIN	ALUM. ALLOY 2024-T3	Q0-A-250/5	0.040" THK. SHEET
1	17	ANGLE	ALUM. ALLOY 2024-T3	Q0-A-250/5	0.040" THK. SHEET
1	16	ARM REST ASSEMBLY	AS NOTED		
1	15	INSTRUMENT PANEL	ALUM. ALLOY 2024-T3	Q0-A-250/5	0.035" THK. SHEET
1	14	WINDOW FRAME	ALUM. ALLOY 2024-T3	Q0-A-250/5	0.040" THK. SHEET
1	13	INSTRUMENT WINDOW	G. E. LEXAN		0.063 THK. SHEET
1	12	FORWARD ROB	SUB-ASSEMBLY		
1	11	ANGLE	ALUM. ALLOY 2024-T3	Q0-A-250/5	0.040" THK. SHEET
1	10	REARWARD ROB	SUB-ASSEMBLY		
1	8	ANGLE	ALUM. ALLOY 2024-T3	Q0-A-250/5	0.040" THK. SHEET
1	6	PUSH ROD - INSTRUMENT PANEL	ALUM. ALLOY 2024-T3	Q0-A-250/5	0.040" THK. SHEET
1	5	ALUMINUM STRIP	ALUM. ALLOY 2024-T3	Q0-A-250/5	0.040" THK. SHEET
1	4	ROBBER STRIP	COMMERCIAL		
1	3	DOOR LUP LATCH ASSEMBLY	AS NOTED		
1	2	PLEXIGLASS BUBBLE WINDOW	DART ARMO PART NO. 2048-1033-1		
1	1	INSTALLATION - DOOR MOUNTED INSTRUMENTS	BUBBLE WINDOW		

[illegible]

Eric Downing

From: Harvey Siemens
Sent: Wednesday, April 09, 2014 8:56 AM
To: Eric Downing
Cc: Patrick Smith; Nigel Forbes; Linda Lacelle
Subject: RE: EA20469-16

Eric,

Drawing changes are in the works. Roberto has finished them and David needs to review but he is aware of the changes coming and is good with them. With regard to the holes, I'm not sure but I believe that they are easily picked up from the door they are being installed on.

Because I'm quite sure that we won't have the drawings approved before you need to ship, I am happy to provide you with deviation authorization if that will get the parts moving.

The deviations are acceptable for release.

Let me know if you need something more specific.

Regards,

Harvey

From: Eric Downing
Sent: April-09-14 6:49 AM
To: Harvey Siemens
Cc: Patrick Smith; Nigel Forbes; Linda Lacelle
Subject: EA20469-16
Importance: High

Good Morning Harvey

I have in front of me the EA20469-16 B115546 purchased on PO23643 and it does not match the supplied drawing. As you can see in the attached pictures the foam cushion doesn't match nor is there any holes in the mounting tube.

I have attached the drawings that was with the parts at inspection. Is there a more up to date drawing that reflects the changes or is the part acceptable as is?

please let me know as soon as you can please due to production wanting to ship today.

Thanks

Eric Downing
QC Coordinator
T: 1-613-632-5200 ext 223
C: 1-613-363-9375
F: 1-613-632-5246
www.dartaero.com



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

Purchase Order ID PO23643

Purchase Order Date 4/4/2014
PO Print Date 4/4/2014

Page Number 1 of 2

Order From :

EAGLE COPTERS MAINTENANCE LTD.
823 MCTAVISH ROAD N E
CALGARY, AB T2E 7G9
CA

VU-EAG002

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

CL/10/04/04

Contact Name

Vendor Phone 403-250-7370

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

USD

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	EA20469-16P	Arm Rest Ass'Y (Vrd)	4/9/2014 Yes 4/9/2014		1.00 Each	\$200.00	\$200.00
AS PER EA20469-16 B115546 PART D4324-041 AND D4324-043 AS BEEN SHIP FOR ASSEMBLY							
Line Total:							\$200.00

2 71401-45

PROCUREMENT
QUALITY CLAUSES

4/9/2014
No
4/9/2014

1.00

\$0.00

\$0.00

Procurement Quality Clauses
A005 right of entry
A016 personnel qualification
A026 certification of material conformance
A040 notification of quality escape
A043 retention of quality documents

Note:

4/4/2014

Eagle Copters Maintenance Ltd

823 McTavish Rd, NE
Calgary, Alberta T2E 7G9
Canada

Packing Slip

April 04, 2014

Telephone: (403) 250-7370

Fax: (403) 250-7110

Shipment number: SH#14-001030

Customer PO number:

Ship To: Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Phone: (613)632-5200

Ship Via: FED EX

Carrier Terms:

Waybill: 798453511806

Customer PO number:

Item	Part Number	Part Description	Current Location	Qty UOM	Serial Number	Lot Number
1	EA20469-16	Arm Rest Assembly (Vrd) From Harvey S		1 Each		

All Parts being sent on this packing slip have the original certification on file at Eagle Copters Ltd.

* End of Report *

>> denotes that the Packing Slip line item has already been printed.